

Date: Friday, 7/4/2008 8:45:43 AM  
User: Kim Johnston

Process Sheet

*SPLIT.*

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 90 DEGREE BLADE SUPPORT ASSY
Job Number	: 40243 -1		
Estimate Number	: 13386		
P.O. Number	:	Part Number	: PB674300167
This Issue	: 7/4/2008 S.O. No. :	Drawing Number	: B6743001 PAGE24
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: B1
Previous Run	: 40024	Material	:
Written By	: <i>[Signature]</i>	Due Date	: 7/10/2008
Checked & Approved By	: <i>[Signature]</i> 08 07.04	Qty:	<i>6</i> Um: Each
Comment	: Est Rev: A 08-06-19 new issue DD verified by: ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6S090	6061-T6 .090 Sheet
-----	-------------	--------------------



Comment: Qty.: 0.6241 sf(s)/Unit Total : 6.2412 sf(s)  
6061-T6 .090 Sheet  
batch: *[Signature]*

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET  
1-Cut as per Dwg B67-43001-147  
Dwg Rev: *81*  
Prog Rev: \_\_\_\_\_  
  
2-Deburr if necessary

*[Signature]*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: Form as per dwg B67-43001

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Date: Friday, 7/4/2008 8:45:43 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 90 DEGREE BLADE SUPPORT ASSY

Job Number: 40243

Part Number: PB674300167

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC5

PB6743001-147

INSPECT WORK TO CURRENT STEP



B 40024



Comment: INSPECT WORK TO CURRENT STEP

7.0

PB6743001149

Side Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Side Plate B20025

08-07-03

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: Weld assembly as per dwg B67-43001

08-07-03

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08/07/07 (x13)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/07/07 (x13)

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

08/07/16 (x13)

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/07/16 (x13) (P10)

13.0

MS21075L3

Nutplate



Comment: Qty.: 6.0000 Each(s)/Unit Total: 60.0000 Each(s)

Nutplate

M108601

08/07/17

14.0

MS20426AD34

RIVET



Comment: Qty.: 12.0000 Each(s)/Unit Total: 120.0000 Each(s)

RIVET

M105978

08/07/17

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: B67-43001-167 PAR #: NA Fault Category: Prod/Prod. Large NCR: Yes No DQA: JD Date: 08/06/08  
 QA: N/C Closed: JD Date: 08/29/08

NCR: <u>40243</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/04/10	#70	welds were found to be <del>incorrect</del> <del>inadequate</del> inadequate along the 2.40" Dm. All parts affected QTY (+10)	<u>JD</u> 08.07.14	Re weld the length of the Dm- 2.40" from Dwg. B67-4300-147/-149. AS per Q52004.	<u>JD</u> 08.07.14	<u>S</u> 08/04/15	<u>JD</u> 08.07.14	<u>S</u> 08/04/15
				Grind welds flush.	<u>SAD</u> 08/07/14	<u>S</u> 08/07/15		
				Re Abomin as per Q57005	<u>JD</u> 08/07/16	<u>S</u> 08/07/16		<u>S</u> 08/07/15

NOTE: Date & initial all entries



Date: Friday, 7/4/2008 8:45:43 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 90 DEGREE BLADE SUPPORT ASSY

Job Number: 40243

Part Number: PB674300167

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: Assemble as per dwg B67-43001

*CP 08/07/22 (6)*

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*S 08/07/22 (+6)*

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *UA*

*08.07.24*

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*08/06/08*

Job Completion



*08.08.06*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

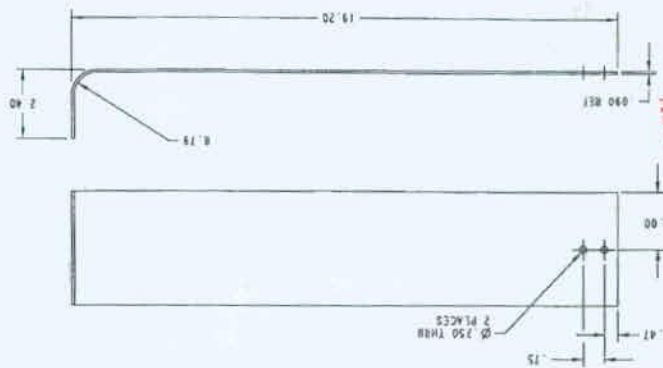
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

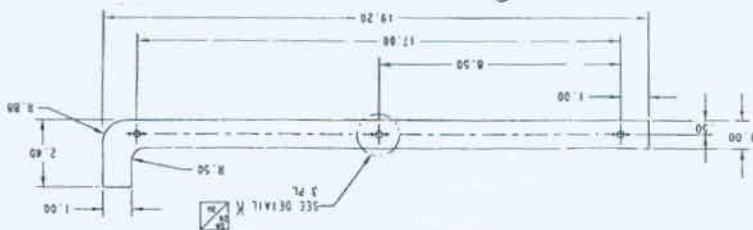
ORIGINAL

PREMIER AVIATION, INC.  
1000 AVIATION PARKWAY, CHANDLER, TEXAS 75006  
DISTRIBUTION NO. 867-43001  
REV. 1.0

② -147 SUPPORT PLATE  
MATERIAL: 0.090 THK, 6061-T6, 00-A-250/11  
SCALE: 0.500



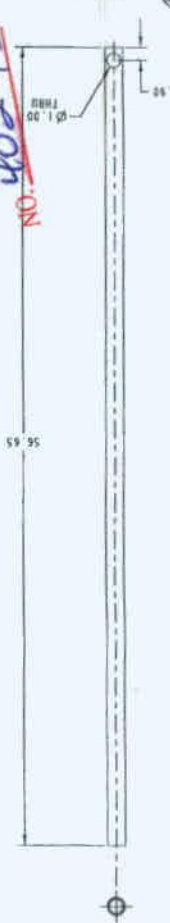
③ -149 SIDE PLATE  
MATERIAL: 0.090 THK, 6061-T6, 00-A-250/11  
SCALE: 0.500



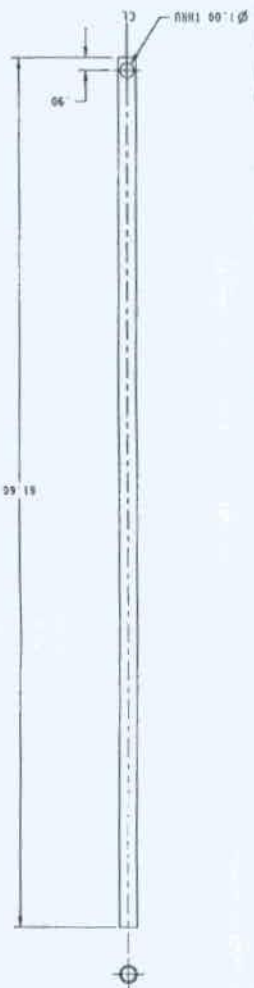
④ -155 PIN  
MATERIAL: 250 HND, 303 SS  
ANNEAL COND A  
SCALE: 2.000



⑤ -259 INNER TUBE  
MATERIAL: 1.25 OD X 1.25 WALL, 6061-T6, 00-A-1700/6  
SCALE: 0.250



⑥ -255 INNER TUBE  
MATERIAL: 1.25 OD X 1.25 WALL, 6061-T6, 00-A-1700/6  
SCALE: 0.250



SHOP COPY  
RETURN TO  
ENGINEERING COPY  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
40273  
NO.

RELEASED  
7-26-70



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries